



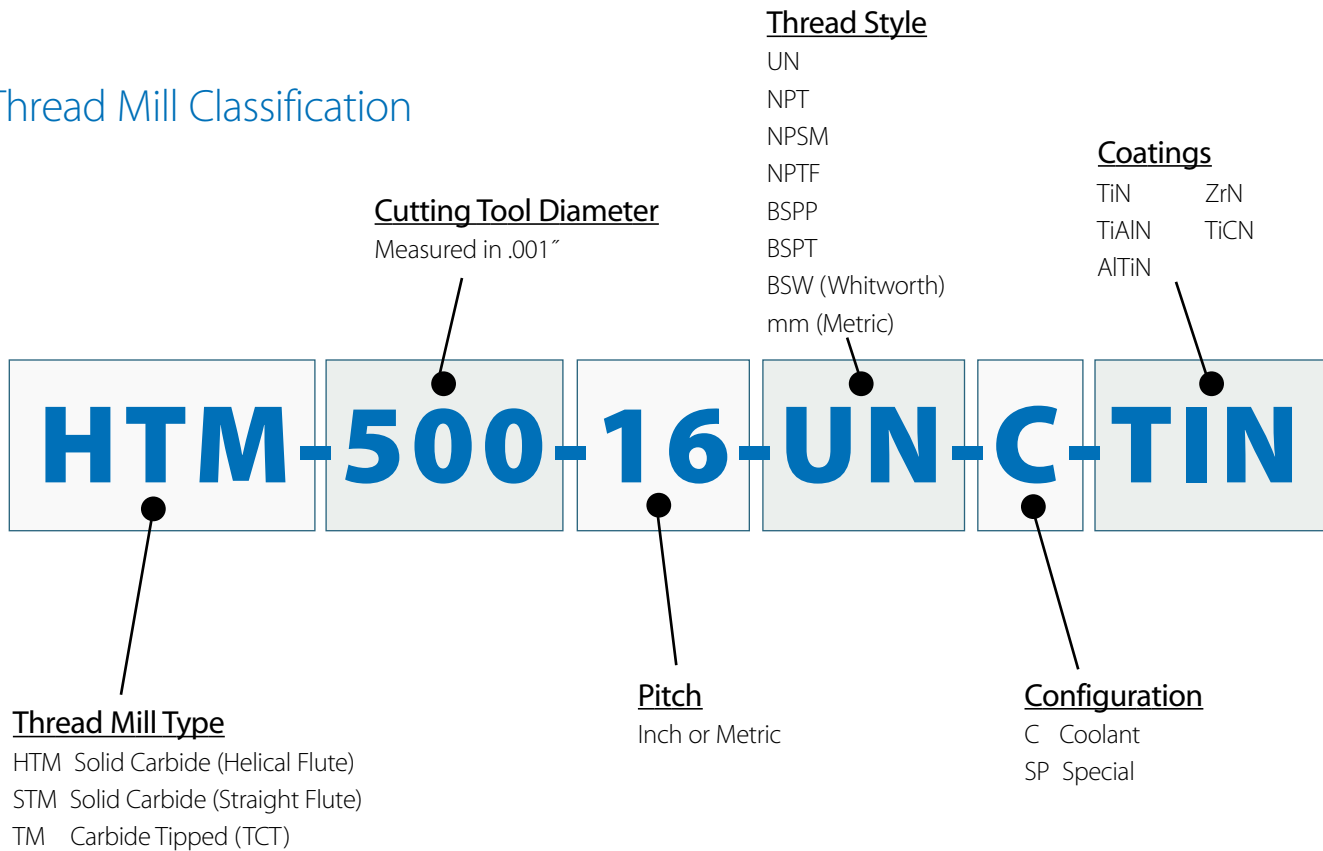
## Thread Mill Data

Suggested Speeds and Feeds for Solid Carbide and Carbide Tipped Thread Mills

The following are starting points and assume ideal manufacturing conditions (please adjust for your circumstances):

MATERIAL	SURFACE FEET PER MINUTE (SFM)	CUTTER DIAMETER (inches)				
		.250-.350	0.500	0.750	1.000	2.000
		FEEDS (inches per tooth)				
Aluminum and Magnesium	800-up	.002-.004	.003-.006	.004-.008	.006-.009	.007-.010
Brass	500-600	.002-.003	.003-.005	.004-.008	.005-.009	.007-.010
Bronze	400-600	.002-.003	.003-.005	.005-.007	.005-.008	.006-.009
Hard Bronze	220-280	.001-.002	.002-.003	.004-.006	.004-.007	.005-.008
Cast Iron - Soft	200-280	.001-.002	.002-.004	.003-.005	.004-.007	.005-.008
Cast Iron - Hard	180-250	.001-.002	.002-.003	.003-.004	.004-.005	.005-.006
Steel - Soft	230-400	.002-.003	.002-.004	.005-.005	.003-.006	.004-.007
Steel - Medium	200-350	.001-.003	.001-.003	.002-.004	.003-.005	.004-.007
Steel - Hard	120-220	.001-.002	.001-.003	.002-.004	.002-.004	.002-.005
Stainless Steel	120-220	.001-.002	.001-.003	.002-.004	.002-.004	.002-.005

## Thread Mill Classification





# ThreadMills by TOOLFAB



## SOLID CARBIDE THREAD MILLS - HELICAL FLUTE (HTM)

Standard						Metric						
TOOL NO.	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	LENGTH OF CUT	# OF FLUTES	TOOL NO.	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	LENGTH OF CUT	# OF FLUTES	MIN. THREAD
HTM225-18	0.225	0.25	2.5	0.75	3	HTM250-75mm	0.25	0.25	2.5	0.75	3	M10
HTM250-18	0.25	0.25	2.5	0.75	3	HTM250-1.0mm						
HTM250-20						HTM250-1.25mm						
HTM250-24						HTM250-1.75mm						
HTM250-28												
HTM250-32												
HTM350-16	0.35	0.375	3.5	0.75	4	HTM350-1.0mm	0.35	0.375	3.5	0.75	4	M14
HTM350-18						HTM350-1.5mm						
HTM350-20						HTM350-2.0mm						
HTM350-24												
HTM500-12	0.5	0.5	4.0	1.0	4	HTM500-1.0mm	0.5	0.5	4.0	1.0	4	M20
HTM500-14						HTM500-1.5mm						
HTM500-16						HTM500-2.0mm						
HTM500-18												
HTM500-20												
HTM750-8	0.75	0.75	4.0	1.0	6	HTM750-1.5mm	0.75	0.75	4.0	1.0	6	M30
HTM750-12						HTM750-2.0mm						
HTM750-12C						HTM750-3.5mm						
HTM750-14												
HTM750-16												
HTM750-18												
HTM750-20												
*HTM312-27 NPT						0.312						
*HTM370-18 NPT	0.37	0.375	3.5	0.7	4							
*HTM370-18 NPTF	0.37	0.375	3.5	0.7	4							
*HTM490-14 NPT	0.49	0.5	4.0	1.0	4							
*HTM490-14 NPTF	0.49	0.5	4.0	1.0	4							
*HTM750-11.5 NPT	0.75	0.75	4.0	1.0	6							

\*Tapered Pipe Thread



# ThreadMills by TOOLFAB

## SOLID CARBIDE THREAD MILLS - STRAIGHT FLUTE (STM)



Standard						Metric						
TOOL NO.	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	LENGTH OF CUT	# OF FLUTES	TOOL NO.	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	LENGTH OF CUT	# OF FLUTES	MIN. THREAD
STM110-32 STM110-36	0.11	0.25	2.5	0.312	3	STM110-7mm	0.11	0.25	2.5	0.312	3	M4
STM125-24 STM125-28 STM125-32	0.125	0.25	2.5	0.312	3	STM125-8mm STM125-1.0mm	0.125	0.25	2.5	0.312	3	M5
STM187-20 STM187-24 STM187-28 STM187-32 STM187-36	0.187	0.25	2.5	0.5	3	STM187-1.0mm STM187-1.25mm	0.187	0.25	2.5	0.5	3	M7
STM225-18	0.225	0.250	2.5	0.75	3							
STM250-16 STM250-18 STM250-20 STM250-24 STM250-28 STM250-32 STM250-36	0.25	0.25	2.5	0.75	4	STM250-75mm STM250-1.0mm STM250-1.25mm STM250-1.5mm	0.25	0.25	2.5	0.75	4	M10
STM350-12 STM350-13 STM350-16 STM350-18 STM350-20	0.35	0.375	3.5	0.75	4	STM350-1.0mm STM350-1.5mm STM350-2.0mm	0.35	0.375	3.5	0.75	4	M14
STM375-12 STM375-13 STM375-16 STM375-18 STM375-20 STM375-24 STM375-28					4							
STM500-11 STM500-12 STM500-14 STM500-16 STM500-18 STM500-20	0.5	0.5	4.0	1.0	4	STM500-1.0mm STM500-1.5mm STM500-2.0mm STM500-2.5mm STM500-3.0mm STM500-3.5mm	0.5	0.5	4.0	1.0	4	M20
STM750-8 STM750-12 STM750-14 STM750-18 STM750-20	0.75	0.75	4.0	1.0	4 6 6 6 6	STM750-1.5mm STM750-2.0mm STM750-3.5mm	0.75 0.75 0.75	0.75 0.75 0.75	4.0 4.0 4.0	1.0 1.0 1.0	6 6 4	M30 M30 M30
*STM250-27 NPT *STM250-27 NPTF *STM312-27 NPT *STM312-27 NPTF *STM370-18 NPT *STM370-18 NPTF *STM490-14 NPT *STM490-14 NPTF *STM750-11.5 NPT	0.25 0.25 0.312 0.312 0.37 0.37 0.49 0.49 0.75	0.375 0.375 0.375 0.375 0.375 0.375 0.5 0.5 0.75	3.5 3.5 3.5 3.5 3.5 3.5 4.0 4.0 4.0	0.7 0.7 0.7 0.7 0.7 0.7 1.0 1.0 1.0	4 4 4 4 4 4 4 4 6							

\*Tapered Pipe Thread

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THREAD MILLS



# ThreadMills by TOOLFAB



## CARBIDE-TIPPED THREAD MILLS (TM)

Standard						Metric						
TOOL NO.	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	LENGTH OF CUT	# OF FLUTES	TOOL NO.	CUTTER DIAMETER	SHANK DIAMETER	OVERALL LENGTH	LENGTH OF CUT	# OF FLUTES	MIN. THREAD
TM350-13 TM350-16 TM350-18 TM350-20 TM350-24 TM350-28 TM350-32	0.35	0.75	6.0	0.75	4	TM350-1.0mm TM350-1.25mm TM350-1.5mm	0.35 8.89	0.75 19	6.0 152.4	0.75 19	4	M14
TM500-10 TM500-11 TM500-12 TM500-14 TM500-16 TM500-18 TM500-20 TM500-24 TM500-28 TM500-32	0.5	0.75	6.0	1.0	4	TM500-1.0mm TM500-1.25mm TM500-1.5mm TM500-1.75mm TM500-2.0mm TM500-2.5mm	0.5 12.7	0.75 19	6.0 152.4	1.0 25.4	4	M20
TM750-9 TM750-12 TM750-14 TM750-16 TM750-18 TM750-20 TM750-24 TM750-28 TM750-32	0.75	0.75	6.0	1.0	4	TM750-1.0mm TM750-1.25mm TM750-1.5mm TM750-1.75mm TM750-2.0mm TM750-2.5mm	0.75 19	0.75 19	6.0 152.4	1.0 25.4	4	M30
TM875-12	0.875	1.0	6.0	1.0	4							
TM1000-7.5 TM1000-8 TM1000-9 TM1000-12 TM1000-14 TM1000-16 TM1000-18	1.0	1.0	7.5	1.3	4	TM1000-1.0mm TM1000-2.0mm TM1000-3.0mm	1.0 25.4	1.0 25.4	7.5 190.5	1.0 25.4	6	M40
TM1250-12 TM1250-16	1.25	1.0	7.5	1.25	6							
TM1500-8 TM1500-12 TM1500-14 TM1500-16	1.5	1.0	8.0	2.0	6							
*TM750-11.5 NPT *TM750-11.5 NPTF *TM750-11.5 NPTFC *TM910-11.5 NPT	1.5	1.0	8.0	2.0	4							
*TM11.5 NPT-1 *TM11.5 NPT *TM 8 NPT	1.0 1.0 1.87	1.0 1.0 1.25	6.0 7.5 8.0	1.0 2.0 2.5	4 4 4							

\*Tapered Pipe Thread. For coolant-through add C to end of #.